

Work Order ID 53320

October 30, 2009 10:17:54 AM



Page 1

Item ID:	D3281-4	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Floor Protector, Aft RH					
Start Date:	30/10/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	16/11/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>09-10-30</u>	Date:	<u>13/</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3281	Rev D								

100		HAND FINISHING THERMOFORMING	0.00						BB 09/11/03 X10
	Thermoform	Memo	0.00						
	Thermoforming Machine	Cut Blanks							
110		THERMOFORMING MACHINE	0.00						BB 09/11/04 X10
	Thermoform	Memo	0.00						
	Thermoforming Machine	Thermoform as per Dwg. D3281 and Folio FTA 010 <input type="checkbox"/> Dwg. Rev. <input checked="" type="checkbox"/> Folio Rev. <u>BB</u>							
120		QC2- Inspect parts off machine FAI/FAIB	0.00						BB 09/11/07 X10
	QC	Memo	0.00						
	Quality Control								

October 30, 2009 10:17:54 AM



Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**

Start Date: 30/10/2009 **Start Qty:** 10.00

Required Date: 16/11/2009 **Req'd Qty:** 10.00

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

150

QC5- Inspect part completeness to step on W/O

0.00



OC

Memo

0.00

Quality Control

$$2) \int_{0.9}^{1.1} \frac{1}{u} du$$

FID

W/O: 53320

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.09	B30	PART CUT FLAT @ 0.95" HIGH				09.11.09 PC (PS) 042	09/11/09

Part No: D3281-4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53320

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Item ID: D3281-4

Accept



Setup Start



Revision ID: D

Stop



Item Name: Floor Protector, Aft RH

Start Date: 30/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Packaging Memo	0.00 0.00							<u>9/11/19</u> <u>700</u> <u>59</u>
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>09/11/20</u> <u>26</u> <u>20</u>

Picklist Print

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Page 1

Work Order ID: 53320

Parent Item: D3281-4RevD

Parent Item Name: Floor Protector, Aft RH

Comments:

Start Date: 30/10/2009

Required Date: 16/11/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	1,550.250	43.3300			
GE PLASTICS LEXAN SHEET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1550.25

106751

6.26

110877

1543.99

BB 09/11/09
(X10)

DART AEROSPACE LTD		Work Order:	53320
Description: Floor Protector, Aft RH		Part Number:	D3281-4
Inspection Dwg: D3281 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL **Date:** 09/11/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.7	✓			
17.1	+/-0.100	17.0	✓			
14.3	+/-0.100	14.25	✓			
0.95	+/-0.030	0.959	✓			
0.25	+/-0.030	N/A				
3.1	+/-0.100	3.1	✓			
0.050	Min	0.065	✓			
0.070	Min	0.074	✓			

Measured by: DL **Date:** 09/11/05
Audited by: S **Date:** 09/11/17
Prototype Approval: N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL <u>JA</u>	<u>DL</u>

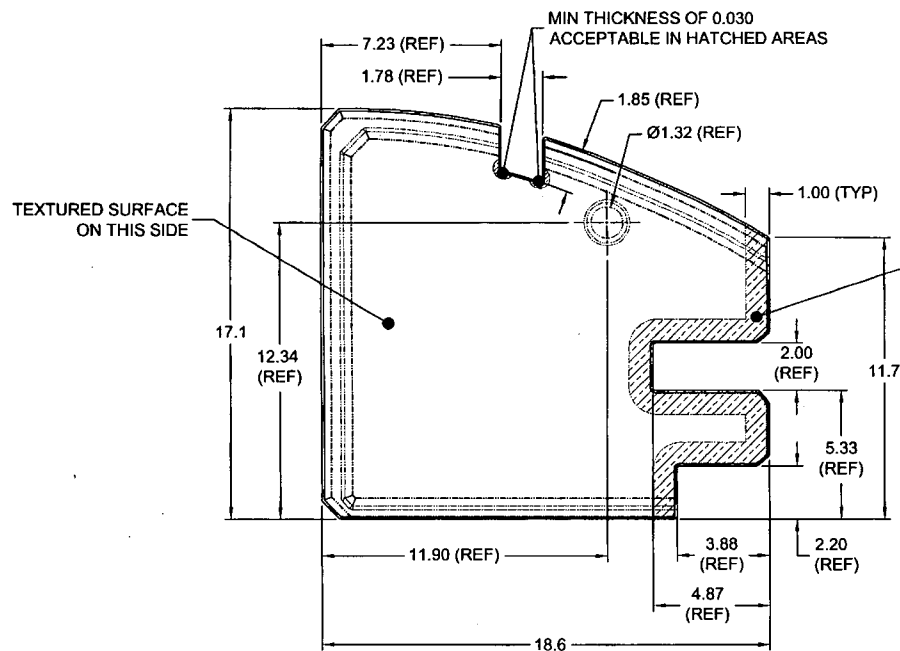
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D

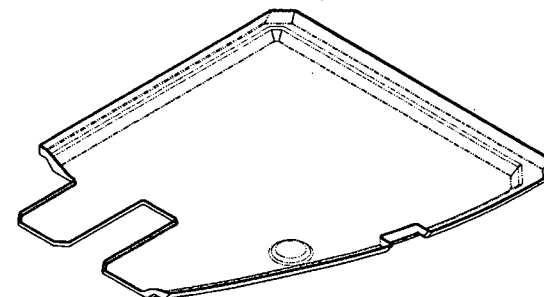
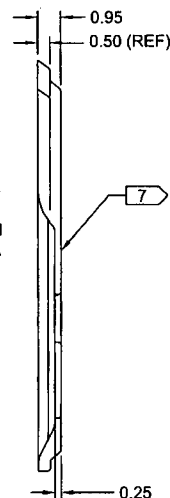
C

B

A



MIN THICKNESS
OF 0.030
ACCEPTABLE IN
HATCHED AREA



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NO. 53320
P/O 09-10-30
11.05.04/11/10/11

D3281-1 FLOOR PROTECTOR

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.95 lb

D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	40	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BA		
CHECKED	3	DRAWING NO.	REV. D
MFG. APPR.	BA	D3281	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	4	FLOOR PROTECTOR	NTS
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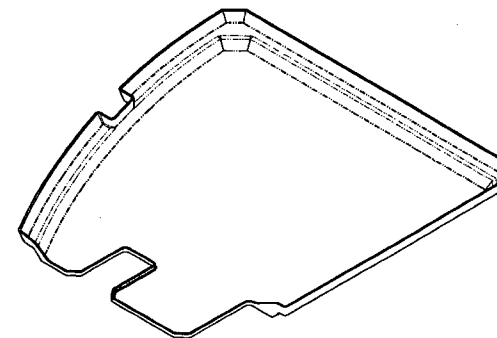
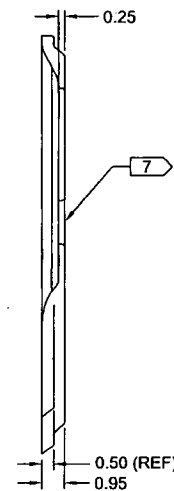
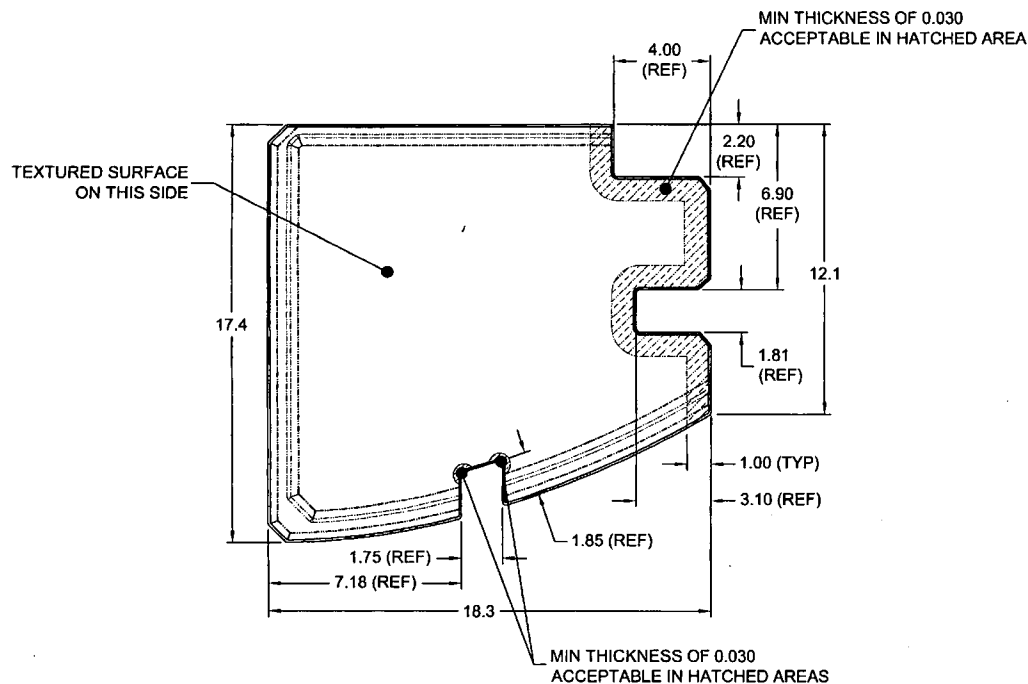
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8 7 6 5 4 3 2 1








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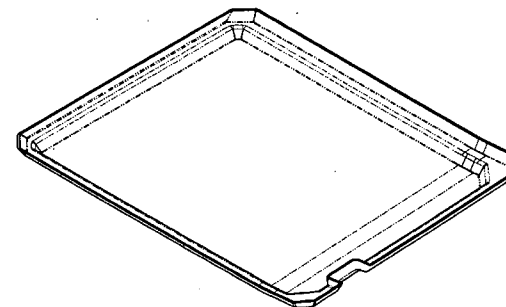
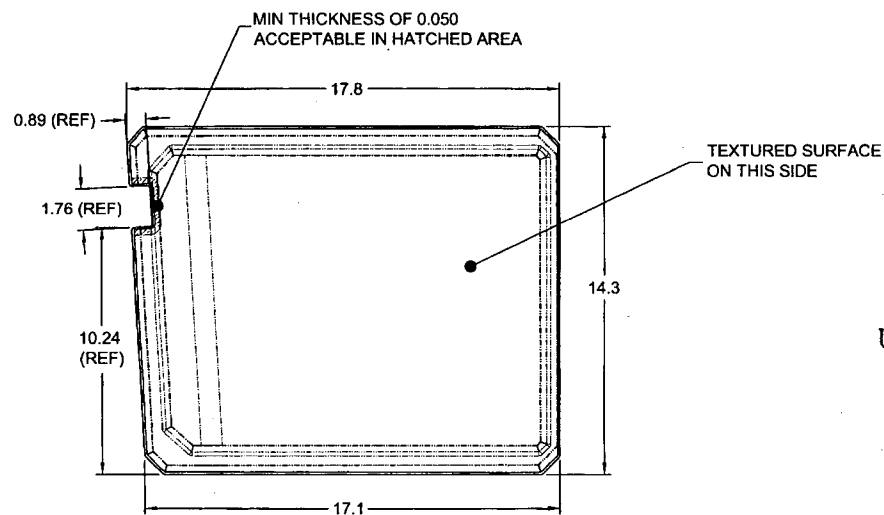
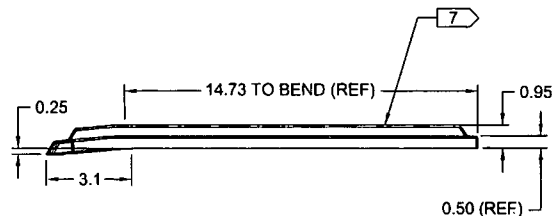
D3281-2 FLOOR PROTECTOR

D3281-2 NOTES:

- 1) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.97 lb

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

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MFG. APPR.		D3281	SHEET 2 OF 4
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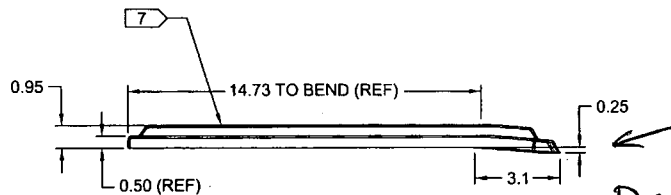
D3281-3 FLOOR PROTECTOR

D3281-3 NOTES:

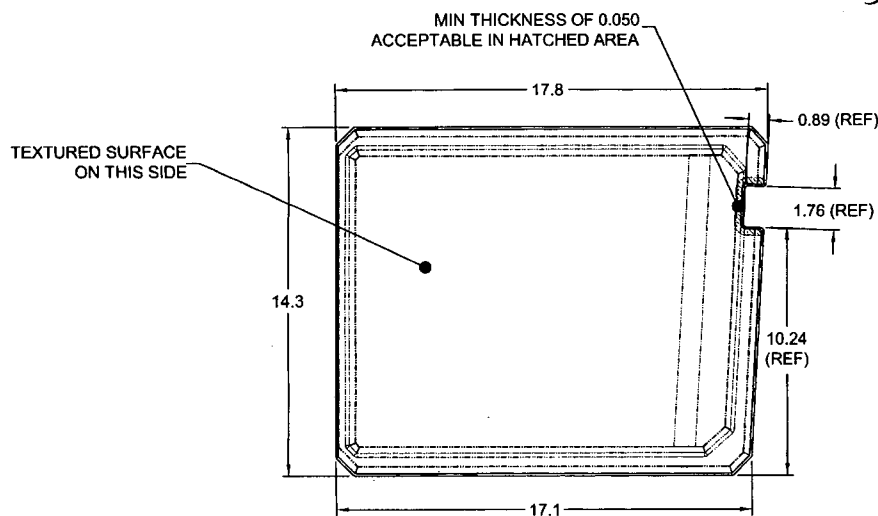
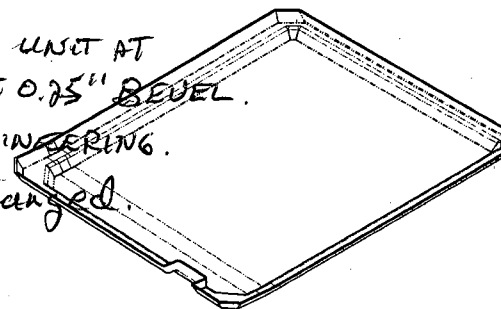
- 1) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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DATE	08.03.28		



TRIM WHOLE UNIT AT
0.95" OMIT 0.25" BEVEL.
AS PER ENGINEERING.
Drops. To BE changed.



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D3281-4 FLOOR PROTECTOR

D3281-4 NOTES:

- 1) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK
(REF DART SPEC MLEXS.093-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS
- 8) WEIGHT: 0.87 lb

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